

CLAIMS

1. A method for the fabrication of a vehicle drop  
glass (1), with a transparent, in particular  
5 curved, pane (2), on the extremity of which a  
support part (3, 3') is to be attached, which  
cooperates with a drive and/or guide device for  
the heightwise movement of the pane (2),  
characterized by the following steps:  
10 - the pane (2) is oriented and attached at several  
predetermined points (P1, P2, P3) of its surface  
in a device adapted to its shape,  
- a curable plastic material is deposited on the  
pane with the aid of at least one tool in the  
15 region of the assembly with the support part and  
is fashioned, in a fixed position in the space  
inside the device, into a fashioned part (5)  
which, after its assembly with the pane (2),  
clearly defines the position of the support part  
20 in relation to the predetermined points (P1, P2,  
P3),  
- the plastic material is cured.
2. The method as claimed in claim 1, characterized in  
25 that the fashioned part is shaped without bonding  
with the pane and is then firmly assembled to the  
pane in the same position.
3. The method as claimed in claim 1, characterized in  
30 that the fashioned part is shaped while bonding  
firmly to the pane.
4. The method as claimed in any one of the preceding  
claims, characterized in that the support part (3;  
35 3') is made of at least one additional part, which  
is attached to the fashioned part (5) in a  
predetermined position by at least one contact  
face (6; 6') fashioned on the latter.

5. The method as claimed in claim 4, characterized in that the support part constituting the additional part is used as a portion of the mold used to shape the fashioned part, by pressing the support part for shaping onto the mass of plastic material constituting the fashioned part.  
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6. The method as claimed in claim 4, characterized in that the support part constituting the additional part is used as a portion of the mold used to shape the fashioned part, by first attaching it in a predetermined spatial position inside the device and by subsequently filling with the plastic mass an intermediate space that exists in the region of assembly between the support part put in place and the surface of the pane.  
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7. The method as claimed in any one of the preceding claims, characterized in that the support part is assembled to the fashioned part by bonding, either with an adhesive deposited in addition or by direct adhesion between the fashioned part and the support part.  
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8. The method as claimed in any one of the preceding claims, characterized in that the support part is assembled to the fashioned part with the aid of mechanical assembly means, in particular by clamping and/or interlocking.  
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9. The method as claimed in claim 1, 2 or 3, characterized in that the fashioned part itself forms at least one portion of the support part, in particular all the support part.  
35
10. A vehicle drop glass (1), in particular for a vehicle door with a frameless pane guide, with transparent, in particular curved, pane (2) on the bottom extremity of which is attached a support

part (3, 3') which cooperates with a drive and/or guide device, characterized in that the spatial position of the fixed support part (3, 3') is oriented in relation to the window (2; 20) with the aid of a fashioned part (5) formed on the pane, at several predetermined points (P1, P2, P3), at least two of which are situated on an edge of closure of the pane.

10 11. The vehicle window pane as claimed in claim 10, characterized in that the fashioned part (5) presents a contact face (6, 6') oriented in relation to several predetermined points (P1, P2, P3) of its surface, for the positioning of the support part (3).

12. The vehicle window pane as claimed in claim 10 or 11, characterized in that two of the predetermined points (P1, P2) are in the region of the upper edge of the pane (2) cooperating with a seal and another point (P3) is disposed close to the fashioned part (5) put in place.

13. The vehicle window pane as claimed in any one of the preceding product claims, characterized in that the fashioned part (5) consists of a curable thermoplastic or plastic material.

14. The vehicle window pane as claimed in any one of the preceding product claims, characterized in that, in the region of the support part (3, 3'), there are provided oriented contact faces (6, 6') of the fashioned part (5), on the two main opposing faces of the window (2).

15. The vehicle window pane as claimed in any one of the preceding product claims, characterized in that the support part (3, 3') is provided with a

threaded hole or with a threaded stud for assembly to a drive or guide device.

- 5           16. The vehicle window pane as claimed in any one of  
the preceding product claims, characterized in  
that the pane (2), the contact face (6, 6') and  
where necessary the support part (3, 3') are  
respectively provided with at least one recess  
(4), the recesses aligned one with the other  
10           having, passing through them a bolt or a screw for  
assembly with a drive or guide device.